



Commodity Specification

GRILLED CHICKEN PATTIES

APRIL 2000



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I. GENERAL

Frozen, fully cooked, grilled chicken patties (commodity) produced under this Specification will be packaged and packed in the following form as specified in the contract:

Grilled Chicken Patties (223130) - Frozen, fully cooked, grilled chicken patties, produced from boneless, skinless thighs (only) and skin, or boneless, skinless thighs and drumsticks and skin. Grilled chicken patties will be packaged 5 or 10 pounds (2.27 or 4.54 kg) per plastic-film bag to a net weight of 30 pounds (13.61 kg) in each fiberboard shipping container. A purchase unit will consist of 1,300 shipping containers totaling 39,000 pounds (17,690 kg).

The description of the product is grilled “ground and formed dark chicken patties.”

II. COMMODITY SPECIFICATIONS

A. Basic Requirements

1. Date Processed. The commodity must not be processed prior the date of the contract.

2. Class. The commodity must be prepared from freshly slaughtered chickens (broiler/fryers, 9 C.F.R. Part 381 or AMS § 70.201(c)).

3. Origin of Chickens. The commodity must be produced and processed from chickens which were produced, raised, and processed in the United States, its territories or possessions, the Commonwealth of Puerto Rico, or the Trust Territories of the Pacific Islands. If the contractor processes or handles chicken products originating from sources other than the United States, its territories or possessions, Puerto Rico, or the Trust Territories of the Pacific Islands, the contractor must have an acceptable identification and segregation plan for those chicken products to ensure they are not used in the commodity produced under this Specification. This plan must be made available to a representative of the Grading Branch, Poultry Programs, AMS, USDA (grader), and the Contracting Officer or agent thereof upon request. The contractor must ensure that both the contractor and subcontractor(s) maintain records such as invoices, or production and inventory records evidencing product origin, and make such records available for review by the USDA grader or other Government official(s) in accordance with Article 76 of USDA-1.

II.A.

4. Inspection. Processing operations must comply with Poultry Products Inspection Regulations (9 C.F.R. Part 381) under the supervision of a representative of the USDA Food Safety and Inspection Service (FSIS) (inspector). Inspection for contract and specification compliance will be in accordance with the Regulations Governing the Voluntary Grading of Poultry Products and Rabbit Products (7 C.F.R. Part 70) and the U.S. Classes, Standards, and Grades for Poultry (AMS 70.200 *et seq.*) under the supervision of a USDA grader. The USDA grader will be responsible for certification of compliance with the requirements of this Specification for chilled chicken products; preparation, formulation, and cooking of the commodity; cooked commodity; freezing; packaging and packing; labeling and marking; net weight; and checkloading.

5. Product Temperature. The temperature of chicken and chicken products, size reduced meat and skin, cooked commodity, and the individually frozen commodity, unless otherwise specified herein, must comply with 9 C.F.R. § 381.66 and FSIS Directive 7110.3 (Time/Temperature Guidelines For Cooling Heated Products) throughout all operations including transportation between plants.

6. USDA Sampling Option. USDA may select additional commodity for further inspection or may draw samples for laboratory analyses.

7. Chicken Products From Other Plants. Chilled chicken and chicken products may be transferred or obtained from other processing plants, provided they: (1) have been processed, handled, and identified in accordance with this Specification, and (2) comply with the freshly slaughtered, organoleptic, temperature, and other applicable requirements of this Specification as evidenced by USDA certification.

a. Type, class, and specific name of the product; date slaughtered; and the USDA-assigned plant number must be shown on each shipping container.

b. The chilled chicken and chicken products must be at an internal temperature not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C) when shipped from the origin plant and when received at the destination plant.

B. Requirements for Meat and Skin

1. Time Requirements. The chilled ready-to-cook chicken and bone-in, skin-on chicken parts must be fabricated into cooked commodity within 7 calendar days after the day the chickens are slaughtered. Within this 7-day timeframe, deboned meat and skin from the chicken and chicken parts must be fabricated into cooked commodity within 4 days after deboning.

2. Maximum Temperature. The temperature of the carcasses or boneless parts, meat, and skin must not exceed 55 °F (12.8 °C) at any time during the preparation and processing of these chicken products for use in the commodity.

II.B.

3. Cooling Requirements. The meat and skin which are not used in the commodity on a continuous basis after deboning, must be: (a) cooled by an FSIS approved method or cooling medium, and (b) continuously lowered to an internal product temperature not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C).

4. Cooling Medium.

a. Cooling methods and medium approved by FSIS (e.g., use of carbon dioxide (CO₂) or liquid nitrogen (N₂)) may be used to maintain the temperature of meat and skin.

b. Water, refrigerated water, slush ice and water, or ice used to cool or maintain the temperature of meat and skin must not be incorporated into the commodity. Liquid associated with normal product weepage is acceptable.

5. Meat. The following kinds of boneless, skinless dark meat, in the amounts specified, must be used to prepare the commodity:

a. Dark meat must consist of thigh meat (only) or leg meat (a combination of drumstick and thigh meat in natural proportion as it is removed from the carcass).

(1) Thigh meat. The thigh meat must be boneless and skinless recognizable portions with no more than one-half of the thigh meat missing.

(2) Drumstick meat. Drumstick meat may be used with thigh meat (in natural proportion as it is removed from the carcass). Drumstick meat must be boneless and skinless recognizable portions with no more than one-half of the drumstick meat missing.

b. When formulated as a combination of drumstick and thigh meat, drumstick meat may replace up to 45 percent of the thigh meat used in the formula. This is equivalent to a maximum of 40.28 percent of total weight of the formula (II.C.2.) that could be drumstick meat.

c. The minimum amount of ground dark meat used in the formula must be 89.50 percent of the total weight of the formula.

6. Unacceptable Meat. No frozen or previously frozen chicken or chicken products may be used. Mechanically separated (comminuted), flaked, or finely chopped meat cannot be used.

7. Skin. The skin must be removed from the drumstick or leg meat before size reduction. Feathers and hair must be removed.

II.B.

8. Organoleptic Requirements and Defects.

a. Organoleptic requirements. The skin and boneless, skinless thigh and drumstick meat will be examined on a continuous basis for organoleptic requirements shown in Table 1. Any meat or skin that does not comply with the organoleptic requirements will be rejected for use under this Specification.

b. Defects. Prior to size reduction, 10 pieces of each meat component and skin will be sampled and examined separately for the defects shown in Table 1. The frequency of sampling and the number of defects allowed will be those outlined in Poultry Programs' Sample Plan Level 2 (SPL-2). The examination for bone will be made separately from the examination for other defects.

(1) Regardless of the kind and number of defects (within Table 1) found, any sample with bone or hard bone-like material greater than 0.75 inch (1.91 cm) will be cause for the rejection of the product the sample represents.

(2) If the number of bone defects exceed the maximum for the "target" level, or results in a rejection, the frequency of sampling for bone defects will be increased to 10 pieces of meat and/or skin drawn twice each sampling interval until the cumulative number of bone defects reverts back to the "target" level.

(3) If the sample of meat or skin has more defects than the maximum tolerance for the sample plan, the meat or skin the sample represents will be rejected.

Table 1. Organoleptic Requirements and Defects for Meat and Skin

Organoleptic Requirements:	Criteria: (1) The meat and skin must be free of: (a) rancidity; (b) fruity, sulfide-like, cardboardy, tallowy, oily, metallic, chlorine, other foreign or off-odors; and (c) foreign materials (e.g., glass, paper, rubber, metal). (2) The meat and skin must: (a) show no evidence of mishandling or deterioration, and (b) have a bright color and show no evidence of dehydration or freezing and thawing.
Thigh and Drumstick Meat Defects:	A defect is a boneless, skinless thigh or drumstick with more than one-half of the meat missing.
Additional Meat Defects:	A defect for all boneless, skinless meat is the presence of:
Bone:	Bone or hard bone-like material. Additionally, bone or hard bone-like material greater than 0.75 inch (1.91 cm) shall be cause for rejection of product the sample represents II.B.8.b.(1).)
Other:	Cartilage (gristle), tendon or tendinous material that is soft-like in texture and extends more than 0.50 inches (1.27 cm) beyond the meat tissue. Dark colored (due to blood) artery or vein more than 1 inch (2.54 cm) in length. Bruises or blood clots which exceed an area equivalent to a circle with a diameter of 0.30 inch (0.76 cm). An aggregate area of all discolorations with moderate intensity that exceeds an area equivalent to a circle with a diameter of 1 inch (2.54 cm).
Skin Defects:	A defect for skin is the presence of feathers or hair. A defect for discoloration in skin is when the aggregate area of all discolorations with moderate intensity exceeds an area equivalent to a circle with a diameter of 1 inch (2.54 cm).

C. Formulation and Processing

1. Size Reduction of Meat and Skin.

a. Meat.

(1) All boneless, skinless meat must be ground (once) through a single plate with openings that are 0.375 inch (3/8 inch) (9.53 mm) in diameter. The grinding plate must be designed to extract and discharge incidental bone and bone-like material simultaneously

during the grinding process. The bone collection system must provide a continuous flow of

II.C.1

discharged material during grinding. The discharge material may be collected and used in accordance with FSIS policy, but must not be used in the commodity produced under this Specification.

(2) The USDA grader will verify compliance with the 0.375 inch (9.53 mm) grinding plate diameter requirement by measuring the grinding plate openings at the start of each production run. Additionally, the grader will monitor the equipment to ensure that the bone collection system is functioning properly.

(3) Other methods for bone collection/removal may be used when the methods are reviewed and found acceptable by supervisory personnel of the Grading Branch, Poultry Programs.

b. Skin. Skin must be emulsified or may be ground through a plate with holes that are 0.125 inch (1/8 inch) (3.175 mm) in diameter.

c. Temperature. Ground meat and skin which are not used in the commodity on a continuous basis, must be cooled by an FSIS approved method or cooling medium (e.g., use of CO₂ or N₂) and the internal product temperature lowered to not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C). Water, refrigerated water, slush ice and water, or ice used to cool or maintain the temperature of meat or skin must not be incorporated into the ground product. Liquid associated with normal product weepage is acceptable. No frozen or previously frozen ground meat or skin may be used in the commodity.

2. Formula. The portions of raw chicken products and other ingredients required in preparing the commodity are as follows:

	<u>Percent of Total</u>
Ground Dark Chicken Meat (minimum)	89.50
Skin	3.20
Water (maximum)	5.00
Isolated Soy Protein	0.95
Binder(s)	0.50
Salt (maximum)	0.50
Sodium Phosphate (maximum)	<u>0.35</u>
	100.00

a. Use of restricted phosphates must be in accordance with 9 C.F.R. § 381.147.

II.C.2.

b. Binder(s) must be a food starch. Isolated soy protein may be mixed with water prior to the addition of salt and sodium phosphate.

c. The sodium phosphates must be thoroughly mixed with the water (with or without soy protein) prior to the addition of the salt and other non-meat/skin ingredients to form a solution. The solution (non-meat/skin ingredients) must be uniformly mixed prior to blending with meat and skin ingredients.

d. Formulated batches of ingredients that do not comply with the formula above (II.C.2.) will be rejected for use in the commodity.

3. Blending. The ground meat and emulsified or ground skin must be mechanically blended uniformly with the solution (salt, sodium phosphates, and other ingredients). The meat must not be additionally chopped and/or shredded, or in any manner further reduced in size (to a finely ground or comminuted state) during the blending/mixing process.

4. Forming. The blended, formulated mixture of meat, skin, and other ingredients must be mechanically formed into patties which are uniform in thickness and “breast” or “breast/fillet” shaped.

5. Formed Weight. After forming, the commodity will be sampled and examined for weight. A sample of 10 raw, formed patties will be used to determine the weight.

a. The 10 raw, formed patties in a sample must average not less than 3.05 ounces (86.47 grams).

b. The frequency of sampling will be on a sampling interval basis. If any sample does not comply with the formed weight requirements above, the raw patties the sample represents will be rejected.

6. Glazing/Caramel Color.

a. The formed patty must be coated, brushed, sprayed, or dipped in a glaze (all sides), prior to cooking, to assist in: (1) producing the desired finished product caramel color (II.E.1.), and (2) retaining product moisture during frozen storage and reheating.

b. Finished product caramel color guideline charts can be: (1) reviewed by contacting supervisory personnel of Poultry Programs, and (2) obtained by processors intending to submit bids for this product. Contact the Standardization Branch, Poultry Programs, AMS, USDA, on (202) 720-3506.

c. The use and labeling (in the ingredients statement) of the glaze ingredients must be in accordance with FSIS procedures.

II.C.

7. Reprocessing.

a. Product eligible for reprocessing. Unglazed and uncooked chicken patties may be reprocessed and incorporated into formulated batches of uncooked product, prior to forming into patties.

b. Product ineligible for reprocessing. Glazed or cooked chicken patties cannot be reprocessed for use under this Specification.

D. Cooking and Freezing

1. Processing Sequence. The forming, glazing, cooking/frying, grill marking, and individual freezing of the commodity must be a continuous sequential process.

2. Cooking.

a. Cooking. The commodity must reach an internal temperature of at least 160 °F (71.1 °C) during cooking. The time and temperature of cooking must provide cooked commodity that complies with II.E.1.

b. Oil. If oil is used in the cooking process, the oil must be a vegetable oil. Only corn oil, cottonseed oil, soybean oil, or a mixture of these oils may be used. Use of palm oil, coconut oil, and any other tropical oils is prohibited. Vegetable oil must contain antioxidants, and may contain heavy metal scavengers and antifoaming agents that improve stability and extend use performance of the oil. Kind and amount of such additives must be in accordance with 9 C.F.R. § 381.147.

(1) The vegetable oil must be filtered continuously during the cooking process.

(2) The equipment must be cleaned daily.

(3) The vegetable oil, as used for dipping/coating or in a frying system, must be completely replaced with new vegetable oil when foaming becomes a problem or when off-flavors or off-odors (i.e., metallic, oxidized, beany, soapy, bitter, or rancid) develop.

(4) Vegetable oil used in cooking fish, shellfish, onions, or other foods that impart a flavor to chicken products must not be used for cooking the commodity.

3. Grill Markings. A minimum of three (3) parallel grill markings are required on one side of each cooked chicken patty. The intensity of grill marking (lightness or darkness) will not be considered in the color defect determination.

4. Individual Freezing.

- a. The cooked commodity must be chilled and individually frozen so the individual patties do not stick together after they are packaged and packed in shipping containers.
- b. Immediately after cooking is completed, the internal product temperature of the cooked patties must be lowered continuously by an in-line chilling/freezing system at a rate of cooling which complies with the temperature requirements of FSIS Directive 7110.3.
- c. The determination of commodity for 72-hour freezing verification will be made as the commodity exits the in-line chilling/freezing system as follows:
 - (1) Individually frozen commodity exiting an in-line chilling/freezing system with internal product temperatures higher than 0 °F (-17.8 °C) must be packaged and placed in a freezer. The internal product temperature must be lowered to 0 °F (-17.8 °C) or lower within 72 hours from the time the commodity enters the freezer.
 - (2) Individually frozen commodity exiting an in-line chilling/freezing system with internal product temperatures 0 °F (-17.8 °C) or lower is in compliance with the 72-hour freezing requirement (in II.D.4.c.(1) above).
 - (3) In all cases, the commodity must be placed in a freezer within 4 hours of packaging.

E. Requirements for Cooked Commodity

1. Organoleptic Requirements and Defects.

- a. Organoleptic requirements. A sample of 10 cooked patties will be examined for the organoleptic requirements, shown in Table 2. If any patty in the sample does not comply with the organoleptic requirements, the product the sample represents will be rejected. The contractor/processor may remove product suspected of being out of compliance and reoffer the balance for acceptance.
- b. Defects. Samples of 10 cooked patties will be examined for color defects, the presence of grill markings, and fractured commodity as shown in Table 2. The intensity of grill marking (lightness or darkness) will not be considered in the color defect determination.
 - (1) The frequency of sampling and the number of defects allowed will be those outlined in Poultry Programs' SPL-2.
 - (2) If any sample has more: (a) defects for color (grilled side only), (b) grilling defects (less than three (3) (complete or incomplete) grill markings), or

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(c) fractured pieces than the maximum tolerance for the sample plan, the commodity the sample represents will be rejected.

Table 2. Organoleptic Requirements and Defects for Cooked Commodity

Organoleptic Requirements: Examined after cooking prior to freezing.	Criteria: (a) The commodity must be free of: (i) rancidity; (ii) metallic, overcooked, burnt, scorched, bitter, oxidized, stale, fruity, beany, oily, soapy, or other flavors or odors foreign to properly prepared and cooked grilled chicken patties; and (iii) foreign materials (e.g., glass, paper, rubber, metal). (b) The commodity must not be dry; that is, lack moistness or devoid of moisture. (c) The commodity must not be undercooked; that is, cooked until the juices (fluid and moisture) are clear in color.
Color Defects: Grilled side only examined after cooking prior to freezing.	A defect for color is an individual patty that does not have a caramel color, or one with a caramel color lighter than or darker than the tolerance shown in Poultry Programs' color control guidelines for grilled chicken patties.
Grilling Defects: Examined after cooking prior to freezing.	A grilling defect is an individual patty with less than three (complete or incomplete) grill markings on one surface of the commodity.
Fractured Commodity Defects: Examined after packaging and packing.	A defect for fractured commodity is the separation of individual patties into two or more separate pieces.

2. Metal Detection.

a. Requirements.

(1) The commodity must be examined by a metal detection device:

(a) accepted by FSIS; and (b) capable of detecting metallic contaminants including, but not limited to, stainless steel shavings, metal clips, metal fragments from cutting equipment, and pieces of wire.

(2) The commodity must be presented correctly within the detection field pattern of the device. Procedures used must be appropriate for the dimensions, location, and pattern of the detection field, the "orientation effect" on the sensitivity of the device, the environmental conditions, and the commodity.

b. Operating efficiency and procedures. The operating efficiency of the metal detection device will be determined hourly by the USDA grader by placing a detection test

strip with a sphere of 440 stainless steel in the center of the detection field pattern. Poultry Programs will provide the detection test strip with the stainless steel sphere of the specified diameter.

(1) The commodity must be examined: (a) layered prior to packaging; or after it is (b) packaged; or (c) packed in shipping containers.

(2) The USDA grader will use a detection test strip with: (a) a 1.50 mm (0.0591 inch) sphere for the examination of layered commodity, or (b) a 3.00 mm (0.1181 inch) sphere for commodity examined in a package or a shipping container.

c. Contaminated product. These guidelines do not relieve the contractor of the responsibility to provide a safe product. Commodity suspected of being contaminated with metal, or found to be contaminated with metal, will be handled in accordance with FSIS procedures.

d. Other detection procedures. Other procedures for examination of the commodity may be approved by the Deputy Administrator of Poultry Programs, in writing.

F. Packaging and Packing.

1. Materials. All packaging and packing materials must: (a) comply with the requirements of this Specification; (b) be clean and in new condition; and (c) not impart objectionable odors or flavors to the commodity.

a. Plastic-film bags.

(1) Plastic-film bags must be safe (cannot adulterate product or be injurious to health) for use in contact with food products. The safety of food-contact packaging materials will be determined by FSIS according to the criteria and procedures in 9 C.F.R. § 381.144.

(2) Plastic-film bags for packaging the commodity must be a low-density polyethylene film bag with a wall thickness of not less than 2 mil (0.002 inch). Any seams must provide the same protective qualities as the body of the bag. Plastic-film bags must have: (a) low-temperature flexibility (not brittle) and durability to resist stress-cracking caused by the temperatures of freezing and frozen storage, and (b) the impact strength, tensile strength, and tear resistance to protect the commodity from dehydration, freezer burn, or quality deterioration during the conditions of use.

(3) Metal wire ties, paper-coated wire ties, or staples must not be used for sealing plastic-film bags. Plastic-coated wire ties may be used, provided the wire and plastic are bonded so that under the conditions of use, the wire and plastic do not separate, the wire is not exposed, and the plastic does not crack or break. Further, the ties must be constructed

II.F.1.

to preclude damage to the packaging material and be of sufficient size and contrasting color to make them easily seen.

b. Shipping containers

(1) Requirements. Shipping containers must: (a) be a fiberboard container; (b) be of such size to pack the commodity without slack filling or bulging; (c) protect the commodity from contamination and against loss and damage; (d) withstand the variations in humidity and temperature during the conditions of use; and (e) have the combined facings weight, and the compression strength (edge crush value) to withstand the stresses of handling, shipping, stacking, and storage.

(2) Container bottom. Flaps on the bottom of a shipping container must be securely fastened so the bottom remains securely fastened when the top of the container is opened.

(3) Final closure. Final closure of the shipping containers must be secure and made with commercially acceptable filament-reinforced tape, plastic film packaging tape, non-metallic strapping, adhesive, or other similar types of materials that are applicable for cold temperature storage conditions and that provide for safe handling of the commodity. Steel or wire straps must not be used for the final closure. Staples must not be used for the final closing of shipping containers. Adhesive or staples cannot be used to fasten the top portion of telescope-style containers to the bottom portion. However, staples may be used to manufacture and to assemble the fiberboard shipping containers, provided the staples are fastened into the container and tightly clenched to eliminate sharp edges prior to packing the commodity into the shipping containers.

2. Packaging. Approximately 5 or 10 pounds (2.27 or 4.54 kg) of commodity must be packaged in a plastic-film bag. The bag must be of a length that can be readily and securely closed. The bag must be sealed or closed with a nonmetallic device (except for plastic coated wire ties) that will protect the commodity from contamination, dehydration, and freezer burn.

3. Packing. Six 5-pound (2.27 kg) or three 10-pound (4.54 kg) bags must be packed in a fiberboard shipping container resulting in 30 pounds (13.61 kg) net weight of commodity.

4. Case Count Requirement. A sample of 10 grilled patties (average by weight) and the shipping container (net weight) will be used to determine the number of patties per case. The frequency of sampling will be in accordance with Poultry Programs' instructions.

a. To calculate case count compliance, the USDA grader will average the weight of 10 patties and convert the amount into pounds. The net weight of the shipping container will then be divided by the average weight of the patties.

b. The sample shipping container drawn must be packed with a minimum of 175 chicken patties in each 30 pound (13.61 kg) shipping container.

c. If any sample does not comply with the case count requirement, the product the sample represents will be rejected.

III. LABELING

A. Plastic-film Bags

Name and address of the contractor or processor must not be shown on packaging materials.

B. Shipping Containers

1. Labeling Provisions. Labeling and marking of the shipping containers for the commodity must be in accordance with this Specification. Labeling is subject to the provisions of 9 C.F.R. § 381.132(c). The name and address of the contractor or processor must not be shown on shipping containers.

2. Printing Requirements. Printed, stamped, and stenciled labeling and marking information must be water-fast, nonsmearing, of a contrasting color, clear, and readable.

3. Labeling Format. Any deviation from the labeling requirements in this Specification must be approved by the Contracting Officer, in writing, prior to start of production.

4. Recycle Symbol and Statement. The contractor shall place somewhere on the surface of each recyclable shipping container the recycle symbol shown in EXHIBIT 1. The statement "PLEASE RECYCLE" is to be placed under the symbol. The recycle symbol and statement must be legibly printed in permanent ink.

5. Universal Product Bar Code.

a. A Universal Product Code (UPC), symbol and code, called Interleaved 2 of 5 (I 2/5), must appear on each shipping container. The complete code, including the check digit, must be printed in machine-readable and human-readable form. The start and stop indicators will be included in the bar codes. Printing, readability, and scanability of the bar code must be in accordance with UPC guidelines published by Uniform Code Council, Inc., 8163 Old Yankee Road, Suite J, Dayton, Ohio 45458.

b. The contractor will use the code furnished by USDA. USDA has acquired a unique manufacturer's identification number for the commodity purchase programs and will use a unique item code number for the commodity purchased under this Specification. The contractors need not join Uniform Code Council, Inc.

III.B.5.

c. The 14-digit UPC code for shipping containers of grilled chicken patties is:
1 07 15001 01556 0

d. The UPC code must be placed in the lower right-hand corner of both side panels of the shipping container.

6. Labeling and Marking Information.

a. Requirements. The labeling and marking information must be preprinted, stamped, or stenciled on shipping containers. This information, in essentially the same layout, is provided in EXHIBIT 2, "Label Information for Shipping Containers of Grilled Chicken Patties."

b. "END" and "SIDE" designations. For the purpose of labeling and marking, the "end" and "side" panels may relate to the shortest and longest dimensions of the shipping container at the discretion of the contractor/processor. However, the panels must alternate between "end" panel and "side" panel designation with the two side panels and two end panels being located on opposite panels of the shipping container.

7. TOP PANEL - Labeling and Marking. The following information must appear on the top panel of each shipping container:

a. Type, name, qualifier, description, and ingredients statement. The commodity type; name; qualifying statement, as applicable for glaze ingredients (printed same prominence as the name); and description must be printed on the top panel of each shipping container. The ingredients statement must be printed on the top panel of the shipping container following the commodity description. Ingredients must be listed by proper name and in proper order in accordance with 9 C.F.R. § 381.118. Product ingredients statement must be approved by FSIS.

FROZEN GRILLED CHICKEN PATTIES
Ground and Formed Dark Chicken Patties
Ingredients:

b. Storing instructions. The following storing instructions must be printed on the top panel of the shipping container:

PERISHABLE--KEEP FROZEN
KEEP AT ZERO DEGREE F (-17.8 °C) OR BELOW

c. Key points for handling commodity. Handling information is required on each shipping container of commodity. The "KEY POINTS FOR HANDLING" must be legibly printed on the top panel of each shipping container. This information, in essentially the same layout, is set out in EXHIBIT 2.

III.B.7.

d. Nutritional labeling. A nutritional label, indicating the nutrient content of the commodity, is required on the top panel of each shipping container. **The nutrition information shown on the panel must be calculated from analytical results of one serving equaling one grilled chicken patty.** This nutritional facts information or “nutrition facts panel” must be in compliance with the FSIS nutritional labeling requirements found in 9 C.F.R. § 381.400(b) through § 381.499.

(1) The contractor/processor may select one of the following methods of providing the nutrition facts panel:

(a) Preprinted on the top panel of each shipping container; or

(b) Printed on a pressure-sensitive label and applied to the top panel of each shipping container. The pressure-sensitive label must not cover or conflict with the labeling requirements of this Specification.

(2) NOTE: The nutrition facts information and panel must be pre-approved by FSIS prior to shipment of the commodity. The method of providing and location of this information for each shipping container (preprinted or pressure-sensitive label) must be indicated on the FSIS label application. The pre-approved nutrition information must be provided to the USDA inspection personnel at the plant where the commodity is to be packed for shipment.

8. ONE END Panel - Labeling and Marking. The following information must appear on one end of each shipping container:

a. Name, qualifier, and description. The commodity name; qualifying statement, as applicable for glaze ingredients (printed same prominence as the name); and description must be printed on the “one end” designated panel of each shipping container. The following is required, and the words “GRILLED CHICKEN PATTIES” must be printed in letters at least 1 inch (2.54 cm) high:

GRILLED CHICKEN PATTIES
Ground and Formed Dark Chicken Patties

b. Contract number and pack date. The following information may be preprinted, stamped, or stenciled on the shipping container, or on a separate pressure-sensitive label:

(1) Last five digits of the contract number as it appears in the acceptance wire.

(2) Date packed (month, day, and year).

III.B.8.

c. Inspection mark and plant number. The USDA inspection mark and USDA-assigned plant number must be printed on the “one end” designated panel of each shipping container.

d. Net weight. The following net weight statement must be completed and printed on the “one end” designated panel of the shipping container:

___ Bags Net Combined Weight 30 LBS. (13.61 KG)

e. Storing instructions. The following storing instructions must be printed on the “one end” designated panel of each shipping container:

KEEP FROZEN

9. ONE SIDE Panel - Labeling and Marking. The following information must be printed **on the side panel immediately to the right of the “one end” panel** containing the information designated in III.B.8.:

a. Type, name, qualifier, description, ingredients statement, and legend. The commodity type; name; qualifying statement, as applicable for glaze ingredients; description; ingredients statement; and the legend must be printed on the “one side” designated panel of each shipping container. Ingredients must be listed by proper name and in proper order in accordance with 9 C.F.R. § 381.118. Product ingredients statement must be approved by FSIS.

FROZEN GRILLED CHICKEN PATTIES

Ground and Formed Dark Chicken Patties

Ingredients:

Distributed by USDA in cooperation with State and local
or tribal governments for domestic food assistance programs.

Not to Be Sold Or Exchanged.

b. USDA symbol. The USDA symbol, copy on back of Specification, is to be a minimum of 2.25 inches (5.72 cm) in height, and must be printed on the “one side” designated panel of each shipping container.

c. UPC code. The applicable UPC code (see III.B.5.) must be printed on the lower right-hand corner of both side panels of each shipping container.

10. THE OTHER END Panel - Labeling and Marking. For each shipping container, the following information must appear on the end opposite the panel designated “one end:”

III.B.10.

a. Name and qualifier. The commodity name and qualifying statement, as applicable for glaze ingredients, is required on “the other end” designated panel of each shipping container. **The description is not required on this end of the shipping container.** The words “GRILLED CHICKEN PATTIES” must be printed in letters at least 1 inch (2.54 cm) high:

GRILLED CHICKEN PATTIES

b. USDA symbol. The USDA symbol (see III.B.9.b.) is required on the end opposite the panel designated “one end.”

11. THE OTHER SIDE Panel - Labeling and Marking. For each shipping container, the following information must appear on the side opposite the panel designated “one side:”

a. Type, name, qualifier, description, and legend. The commodity type; name; description; qualifying statement, as applicable for glaze ingredients; and the legend (see III.B.9.a.) must appear on the side opposite the panel designated “one side.” **The ingredients statement is not required on this side of the shipping container:**

FROZEN GRILLED CHICKEN PATTIES Ground and Formed Dark Chicken Patties

Distributed by USDA in cooperation with State and local
or tribal governments for domestic food assistance programs.
Not to Be Sold Or Exchanged.

b. UPC code. The applicable UPC code (see III.B.5.) must be printed on the lower right-hand corner of both side panels of each shipping container.

12. Inventory Control Label. The processor may use a pressure-sensitive label to place any additional information (including bar codes) for processor inventory control purposes. This label may be applied somewhere on the surface of the shipping container. The label must not: (a) contain the contractor or processor name and address, or (b) cover or conflict with the labeling requirements of this Specification.

C. F.a.s. Vessel Deliveries

F.a.s. vessel deliveries that are not source loaded in a seavan are required to show the final destination’s overseas address as provided in the Notice to Deliver. The address must be clearly printed on at least two sides of each pallet.

IV. FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY

A. Material and Net Weight Compliance

1. Verification of Materials and Defects.

a. Verification of packaging and packing materials. The contractor must verify compliance with packaging, packing, and marking material requirements by furnishing the USDA grader the following certification on company stationery signed by a person authorized to do so by the contractor:

“(I) (We) certify that the packaging, packing, and marking materials used for any commodity presented for acceptance under the terms of the Commodity Specification for Grilled Chicken Patties dated April 2000, comply or will comply with the terms of this Commodity Specification.

Name _____

Title _____”

One certification is adequate for all production under this Specification.

b. Packaging defects. Packages in a delivery unit will be examined for defects that affect protection, expose product, or permit dehydration or freezer burn, or quality deterioration during storage, such as tears, holes, or improperly sealed or closed packages.

c. Packing defects. Shipping containers in a delivery unit will be examined for condition, labeling, and marking defects according to the United States Standards for Condition of Food Containers.

d. Tolerance for defects. If samples of packaged commodity or the shipping containers in a delivery unit have more defects than the maximum tolerance for the applicable Poultry Programs’ sample plan, the delivery unit will be rejected.

2. Net Weight.

a. A purchase unit or delivery unit will total 39,000 pounds (17,690 kg) net, or multiples thereof.

b. Each delivery unit, except as provided in IV.A.2.g. below, will be examined for compliance with the net weight requirements at time of checkloading.

c. The tare weight of all packing materials will be determined by weighing a representative sample of all packaging components such as plastic-film bags, clips, and fiberboard containers.

IV.A.2.

d. Fifteen (15) shipping containers will be selected at random from a delivery unit to determine net weight. The total net weight of the 15 shipping containers must be equal to or greater than 450 pounds (204.12 kg).

e. If the total net weight is less than 450 pounds (204.12 kg), the delivery unit will be rejected.

f. A rejected delivery unit may be reworked and reoffered one time only. However, if an individual shipping container in the sample of the reworked delivery unit has a net weight less than 30 pounds (13.61 kg) the delivery unit will be rejected.

g. As an alternative to test weighing at time of checkloading, the contractor may request on-line verification of net weights. Upon receiving the request, a Federal-State supervisor will determine that the facilities and procedures are in accordance with the applicable Poultry Programs' instructions for this Specification.

B. Prerequisites for Loading and Shipping Frozen Commodity

1. Visual Inspection. Frozen cooked commodity showing any evidence of defrosting, refreezing, or freezer deterioration will be rejected for use under this Specification.

2. Internal Product Temperature.

a. Requirements. The internal product temperature of the frozen cooked commodity must be 2 °F (-16.7 °C) or lower at the time of loading. Delivery units with internal product temperatures exceeding 2 °F (-16.7 °C) and up to 5 °F (-15 °C) will be tentatively rejected. Tentatively rejected delivery units may be returned to the freezer and the temperature reduced to 2 °F (-16.7 °C) or lower and reoffered one time only. Delivery units exceeding 5 °F (-15 °C) or delivery units that have been tentatively rejected and exceed 2 °F (-16.7 °C) when reoffered will be rejected for use under this Specification.

b. Optional temperature verification. As an option to verifying internal product temperature at time of loading, the contractor may request an alternate method utilizing product temperature sensing devices. If this option is selected, a Federal-State supervisor will determine that the facilities, equipment, procedures, and the contractors' current level of freezing compliance are in accordance with the established guidelines outlined in the applicable Poultry Programs' instructions for this Specification.

C. Inspection and Checkloading

1. Requirements. Inspection for contract compliance will be made by a USDA representative, in accordance with 7 C.F.R. Part 70, 9 C.F.R. Part 381, and this Specification, at the site of processing, both during and after processing and packaging. A

IV.C.1.

USDA representative may select samples for laboratory analyses or inspect the commodity at any point in transit and after delivery to point of destination. Inspection records must be complete and made available to USDA, as requested, to assure contract compliance.

2. Procedures. Inspection and checkloading required by Articles 54 and 55 of USDA-1 must be performed by a USDA grader. Procedures to be followed and a schedule of fees for these services may be obtained by contacting the nearest Grading Branch field office or the Chief of the Grading Branch, Poultry Programs, AMS, USDA, Room 3938-S, STOP 0258, 1400 Independence Avenue, SW, Washington, D.C. 20250-0258, telephone (202) 720-3271. The quality, quantity, weight, packaging, packing, and checkloading of the commodity must be evidenced by USDA certificates issued by the USDA grader. The contractor must not ship the commodity unless informed by the USDA grader that the designated commodity to be shipped meets contract specifications.

V. UNITIZATION

Each delivery unit must be unitized (palletized and stretchwrapped) and comply with the following:

A. Pallets

Pallets must be good quality, wood, 48 inches x 40 inches, nonreversible, flush stringer, and partial fourway entry. Each pallet of shipping containers must be stretchwrapped with plastic film in a manner that will secure each container and layer of containers on the pallet. Palletized product must be loaded in a way that will prevent shifting and damage to the containers of product.

B. Pallet Exchange

Contractors may arrange for pallet exchange with consignees; however, USDA is in no way responsible for such arrangements.

VI. SHIPMENT AND DELIVERY

Shipment and delivery must be made in accordance with this Specification, the applicable Announcement and Invitation, and Articles 56, 57, and 64 of USDA-1, as amended by the Announcement. In addition, the contractor must adhere to the following provisions:

A. Contract Compliance Stamp

Each shipping container must be identified with a USDA Contract Compliance stamp with the applicable certificate number. A USDA grader, or other authorized personnel under the supervision of the USDA grader, will stamp one end of each shipping container prior to

shipment. If there is inadequate space available on either end of the shipping container, the stamp may be applied to a side of the container.

B. Grading Certificate

A copy of the original USDA Poultry Products Grading Certificate issued at time of checkloading must accompany each shipment.

1. Railcar or Piggyback. If shipment is by rail or piggyback, the certificate must be placed in the railcar or trailer for easy access to the USDA grader, warehouseman, or consignee, as applicable.

2. Trucks. If shipment is by truck, the driver must, upon delivery, give the certificate to the USDA grader, warehouseman, or consignee, as applicable.

C. Loading and Sealing of Vehicles

Loading must be in accordance with good commercial practices and the sealing must be done at origin under the supervision of a USDA grader.

1. Railcar. Each railcar must be sealed. The contractors are responsible for arranging railcar deliveries of more than one delivery unit so that each delivery unit contained in the same railcar can be completely separated and sealed.

2. Truck or Piggyback. Truck or piggyback shipments must be sealed at origin. A delivery unit shipped by truck or piggyback which includes split deliveries to two destinations will not require separation by sealing each drop.

D. Delivery Notification

Notwithstanding the provisions of Article 56(c) of USDA-1, as amended by the applicable Announcement, the contractor must follow the instructions in the Notice to Deliver issued by the Kansas City Commodity Office (KCCO) concerning delivery notification. Such notification and information of impending delivery are vital in proper execution of delivery. The contractor must notify the State distributing agency and the consignee of shipment per instructions in the Notice to Deliver. For rail or piggyback shipments, notification shall be made on the day of shipment. For truck shipments, notification of the estimated arrival time should be made as far in advance of delivery as possible. In addition, for truck or piggyback shipments, the contractor must request and keep scheduled appointment(s). Unloading appointments for truck or piggyback shipments must be requested from the consignee contact party(ies) at least 24 hours in advance of delivery.

1. In-Plant Deliveries. When in-plant delivery is made, the contractor must notify the appropriate resident USDA grader and furnish applicable information.

VI.D.

2. Delivery In Storage. Delivery may be made in store provided the destination in the Notice to Deliver and the place the contractor has the commodity in storage are the same. Inspection and certification by a USDA grader are also required for transfers in store.

3. Early Delivery. The contractor may deliver early upon approval of the KCCO. Approval may be obtained by telephoning (816) 926-6068. Approval is contingent on the recipient's concurrence to accept early delivery and upon the USDA grader being available to perform necessary checkloading and final acceptance duties.

E. Split Deliveries

The contractor is responsible to deliver the quantity stated on each Notice to Deliver to each destination. Contractors must provide to the USDA Grader, at time of shipment, the number of boxes and pounds for each destination.

At the option of the contractor, a purchase unit with two Notices to Deliver (split deliveries) for two different destinations may be delivered on two separate trucks provided each truck ships the total quantity stated on the Notice to Deliver. Any additional costs will accrue to the contractor's account.

VII. DESTINATION EXAMINATION

The cost of a destination examination, before or after delivery, by a USDA grader on accepted product will be for the account of USDA. Costs for destination examinations of rejected delivery units will be for the account of the contractor. The USDA origin grader will make arrangements for destination examination prior to delivery.

A. Commodity Requirements

Before acceptance by consignee, the commodity may be examined by a USDA grader on a spot-check basis for temperature, condition, identity, and when applicable, count. The commodity may be examined for conformance to contract provisions at any time required by the Contracting Officer.

B. Temperature

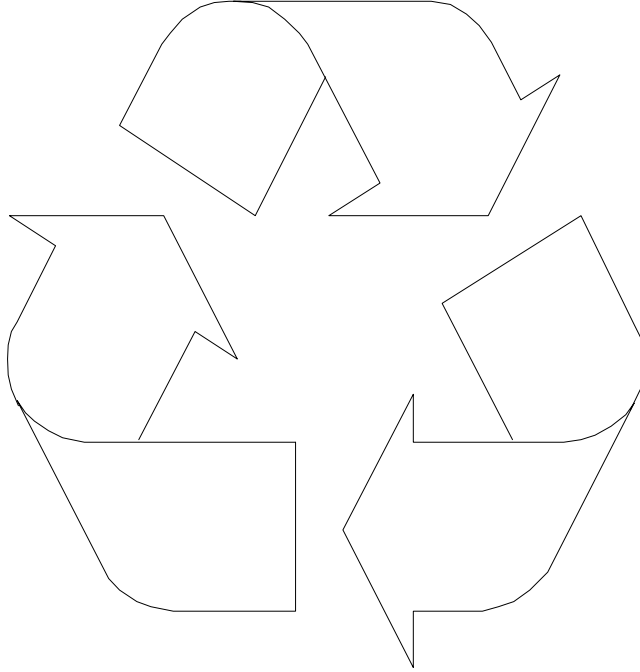
The commodity must arrive at destination at an average internal product temperature not to exceed 10 °F (-12.2 °C) with no individual temperature exceeding 15 °F (-9.4 °C).

Commodity not meeting these requirements will be rejected for use under this Specification.

D. Michael Holbrook
Deputy Administrator, Poultry Programs

Attachment

EXHIBIT 1
“Please Recycle” Symbol and Statement





**PLEASE
RECYCLE**

EXHIBIT 2

Label Information for Shipping Containers of Grilled Chicken Patties

Marking Information: Shipping containers shall be marked substantially as shown below. Markings must be preprinted, stamped, or stenciled on containers, water-fast, nonsmearing, of a contrasting color, clear, and readable. The words “GRILLED CHICKEN PATTIES,” on each end, must be in letters at least 1 inch (2.54 cm) high. A qualifying statement, as applicable, e.g., for glaze ingredients (printed as prominent as the name), must be provided in accordance with FSIS Labeling requirements. The USDA symbol is to be a minimum of 2.25 inches (5.72 cm) in height. The UPC 14-digit I 2/5 bar code (1 07 15001 01556 0), symbol and code, must be shown in the lower right-hand corner of both side panels. The recycle symbol and statement must be legibly printed somewhere on the surface of each recyclable shipping container.

 <p style="font-size: 1.2em; font-weight: bold;">GRILLED CHICKEN PATTIES</p>		
<p style="text-align: center; font-weight: bold;">FROZEN GRILLED CHICKEN PATTIES</p> <p style="text-align: center;">Ground and Formed Dark Chicken Patties</p> <p style="text-align: center;">Distributed by USDA in cooperation with State and local or tribal governments for domestic food assistance programs.</p> <p style="text-align: center;">Not To Be Sold Or Exchanged.</p> <p style="text-align: center;">UPC Code</p>	<div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p style="text-align: center; font-weight: bold;">KEY POINTS FOR HANDLING FROZEN GRILLED CHICKEN PATTIES</p> <p style="text-align: center;">Ground and Formed Dark Chicken Patties</p> <p>Ingredients:</p> <p style="text-align: center; font-weight: bold;">Handle Properly To Avoid Spoilage Or Possible Food Poisoning.</p> <p>Do Not Thaw Before Heating. If Grilled Chicken Patties Thaw Accidentally--Heat And Serve-- Do Not Refreeze.</p> <p>PRODUCT: The grilled chicken patties are made with ground dark chicken. They are precooked and ready to heat and serve.</p> <p>HEATING: Place frozen chicken patties, grilled side up, in a single layer on sheet pans. Heat thoroughly to an internal temperature of 160°F (71.1°C). Watch time closely as oven temperatures vary and overcooking decreases product acceptability.</p> <p>Estimated Heating Times and Temperatures Are: Deck Oven 425°F (218°C) - 17 to 25 min Convection Oven 375°F (191°C) - 11 to 15 min</p> <p>SERVING: Serve promptly. Refrigerate leftovers and use within 2 days.</p> <p>YIELD: One grilled chicken patty provides one 2-ounce (56.7 g) serving of cooked chicken. One 30-pound (13.61 kg) shipping container provides a minimum of 175 servings.</p> </div> <div style="width: 45%;"> <p>SUGGESTED SERVINGS: Grilled chicken patties may be served as an entree with mushroom and onion gravy. Or, serve patties sandwich style on a bun, Kaiser or onion roll, Texas toast, or English muffin. Sandwich toppings include lettuce, tomato, onion, cheese, taco sauce, cranberry relish, or sweet and sour sauce.</p> <p style="text-align: center; margin-top: 20px;">Nutrition Facts Panel May Be Placed Here.</p> <p style="text-align: center; font-weight: bold; margin-top: 20px;">PERISHABLE--KEEP FROZEN</p> <p style="text-align: center; font-weight: bold;">KEEP AT ZERO DEGREE F (-17.8 °C)</p> <p style="text-align: center; font-weight: bold;">OR BELOW</p> </div> </div>	<p style="text-align: center; font-weight: bold;">FROZEN GRILLED CHICKEN PATTIES</p> <p style="text-align: center;">Ground and Formed Dark Chicken Patties</p> <p style="text-align: center;">Ingredients:</p> <p style="text-align: center;">Distributed by USDA in cooperation with State and local or tribal governments for domestic food assistance programs.</p> <p style="text-align: center;">Not To Be Sold Or Exchanged.</p> <p style="text-align: center;">UPC Code</p> 

GRILLED CHICKEN PATTIES
Ground and Formed Dark Chicken Patties



KEEP FROZEN

___ Bags Net Combined Weight
30 LBS. (13.61 KG)

CONTRACT NO. _____
DATE PACKED Month, Day, Year